

5109

DART AEROSPACE LTD	Work Order:	22625
		D3369-041
Description: Dual Disabling Kit (Light Bell)	Part Number:	D206-739-011
	Keyed:	<input type="checkbox"/> Alike <input type="checkbox"/> Unalike
Dwg: D3369 Rev. A; D3370 Rev. A	Qty:	4
		Page 1 of 3

Step	Location	Procedure	By	Date	Qty																				
1	DC	Issue Traveler	PH	05.03.03	4																				
2	DC	Photocopy bluefile and create labels per PPP-D206-739-011 CHG001	NIA																						
3	GA	Pick: <table border="1"> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>1</td> <td>D2728-7</td> <td>Decal</td> <td>M15464</td> </tr> <tr> <td>1</td> <td>D3369-1</td> <td>Battery Lock Body</td> <td>B 22284A</td> </tr> <tr> <td>1</td> <td>D3369-3</td> <td>Cam Lock Shaft</td> <td>B 22272B</td> </tr> <tr> <td>1</td> <td>D3373-1</td> <td>Cam Lock</td> <td>B 22573</td> </tr> </tbody> </table>	Qty	Part Number	Description	Batch	1	D2728-7	Decal	M15464	1	D3369-1	Battery Lock Body	B 22284A	1	D3369-3	Cam Lock Shaft	B 22272B	1	D3373-1	Cam Lock	B 22573	2	05-03-03	4
Qty	Part Number	Description	Batch																						
1	D2728-7	Decal	M15464																						
1	D3369-1	Battery Lock Body	B 22284A																						
1	D3369-3	Cam Lock Shaft	B 22272B																						
1	D3373-1	Cam Lock	B 22573																						
4	GA	Open D3373-1 lock package. Keep keys, lock body, lock body nut, flat cam and lock barrel. Discard the rest.	2	05-03-03	4																				
5	GA	Using the flat cam, fabricate D3369-5 as per Dwg D3369 Identify as D3369-5	2	05-03-03	4																				
6	GA	Assemble D3369-041 as per Dwg D3369. Insert lock body and fasten with lock body nut, then insert lock barrel. Insert D3369-5 fabricated washer and 5/16" SS washer. Thread D3369-3 shaft into lock, then install decal. Pick: <table border="1"> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>1</td> <td>D3369-5</td> <td>Washer</td> <td>BAB22573</td> </tr> <tr> <td>2</td> <td>5/16WC</td> <td>SS Flat Washer</td> <td>M15715</td> </tr> </tbody> </table> Identify as D3369-041 and attach keys Record the Key Number on page 3	Qty	Part Number	Description	Batch	1	D3369-5	Washer	BAB22573	2	5/16WC	SS Flat Washer	M15715	2	05-03-03	4								
Qty	Part Number	Description	Batch																						
1	D3369-5	Washer	BAB22573																						
2	5/16WC	SS Flat Washer	M15715																						
7	WS	Tack Weld lock shaft to flat cam Pick: <table border="1"> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>A/R</td> <td>N/A</td> <td>Steel Rod</td> <td>N/A</td> </tr> </tbody> </table>	Qty	Part Number	Description	Batch	A/R	N/A	Steel Rod	N/A	PD	05-03-03	4												
Qty	Part Number	Description	Batch																						
A/R	N/A	Steel Rod	N/A																						
8	FP	Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3 Mask Dowel Pins Pick: <table border="1"> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>1</td> <td>D3370-1</td> <td>Pedal Lock Base</td> <td></td> </tr> <tr> <td>1</td> <td>D3370-3</td> <td>Pedal Lock Cover</td> <td></td> </tr> <tr> <td>1</td> <td>D3385-1</td> <td>Hinge</td> <td></td> </tr> </tbody> </table> Identify as D3370-051	Qty	Part Number	Description	Batch	1	D3370-1	Pedal Lock Base		1	D3370-3	Pedal Lock Cover		1	D3385-1	Hinge								
Qty	Part Number	Description	Batch																						
1	D3370-1	Pedal Lock Base																							
1	D3370-3	Pedal Lock Cover																							
1	D3385-1	Hinge																							
9	QC3	Inspect Powder Coat																							
10	GA	Press dowel pins into D3370-3 pedal lock cover, then assemble hinge as per Dwg D3370 Pick: <table border="1"> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>1</td> <td>D2728-7</td> <td>Decal</td> <td></td> </tr> <tr> <td>1</td> <td>D3373-5</td> <td>Cam Lock</td> <td></td> </tr> <tr> <td>4</td> <td>AN526C832R</td> <td>Screw</td> <td></td> </tr> <tr> <td>3</td> <td>N/A</td> <td>Ø3/16" Dowel Pin 1/2" long</td> <td></td> </tr> </tbody> </table>	Qty	Part Number	Description	Batch	1	D2728-7	Decal		1	D3373-5	Cam Lock		4	AN526C832R	Screw		3	N/A	Ø3/16" Dowel Pin 1/2" long				
Qty	Part Number	Description	Batch																						
1	D2728-7	Decal																							
1	D3373-5	Cam Lock																							
4	AN526C832R	Screw																							
3	N/A	Ø3/16" Dowel Pin 1/2" long																							
11	GA	Open D3373-5 lock package. Keep keys, lock body, lock body nut, screw, offset cam and lock barrel. Discard the rest.	NIA																						
12	GA	Fabricate D3373-5 Cam Lock as per Dwg D3370 Identify as D3373-5																							

RELEASED
 05-01-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD		Work Order:	22625
Description: Dual Disabling Kit (Light Bell)		Part Number:	D3369-041 D206-739-011
		Keyed:	<input type="checkbox"/> Alike <input type="checkbox"/> Unalike
Dwg: D3369 Rev. A; D3370 Rev. A		Qty:	4
		Page 2 of 3	

Step	Location	Procedure	By	Date	Qty																
13	GA	Assemble lock mechanism and cam and install decal as per Dwg D3370																			
14	GA	Assemble lanyard to cyclic sock as per Dwg D3384 Pick: <table><thead><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr></thead><tbody><tr><td>1</td><td>D3384-1</td><td>Cyclic Sock</td><td></td></tr><tr><td>2</td><td>CBL-460</td><td>Loop Sleeve</td><td></td></tr><tr><td>24"</td><td>CBL-1240</td><td>Cable</td><td></td></tr></tbody></table> Identify as D3384-041	Qty	Part Number	Description	Batch	1	D3384-1	Cyclic Sock		2	CBL-460	Loop Sleeve		24"	CBL-1240	Cable				
Qty	Part Number	Description	Batch																		
1	D3384-1	Cyclic Sock																			
2	CBL-460	Loop Sleeve																			
24"	CBL-1240	Cable																			
15	GA	Assemble D3384-041 to D3370-051 using 1/4"-20 socket head cap screw and washer as per Dwg D3370. Pick: <table><thead><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr></thead><tbody><tr><td>2</td><td>AN960-416</td><td>Washer</td><td></td></tr><tr><td>1</td><td>HX-81</td><td>1/4"-20 SHCS 3/8" long</td><td></td></tr></tbody></table> Identify as D3370-041 & attach keys Record the Key Number on page 3	Qty	Part Number	Description	Batch	2	AN960-416	Washer		1	HX-81	1/4"-20 SHCS 3/8" long								
Qty	Part Number	Description	Batch																		
2	AN960-416	Washer																			
1	HX-81	1/4"-20 SHCS 3/8" long																			
16	QC5	Inspect work to Step 15																			
17	PK	Ensure that keys are attached to D3369-041 and D3370-041 Pick: <table><thead><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr></thead><tbody><tr><td>1</td><td>D3369-041</td><td>Battery Lock Assembly</td><td>B22625</td></tr><tr><td>1</td><td>D3370-041</td><td>Pedal Lock Assembly</td><td>N/A</td></tr></tbody></table> Ensure that keys can be locked and unlocked for each D3369-041 and D3370-041 assembly.	Qty	Part Number	Description	Batch	1	D3369-041	Battery Lock Assembly	B22625	1	D3370-041	Pedal Lock Assembly	N/A							
Qty	Part Number	Description	Batch																		
1	D3369-041	Battery Lock Assembly	B22625																		
1	D3370-041	Pedal Lock Assembly	N/A																		
18	QC4	Inspect Kit 100% for Completeness on the W/O																			
19	PK	Identify and pack for shipping as per PPP D206-739-011 Stock																			
20	AC	Cost / part: 17.09																			
21	DC	Close W/O 17.09 Inspect Level 21																			

BY 0

RELEASED
05-21-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

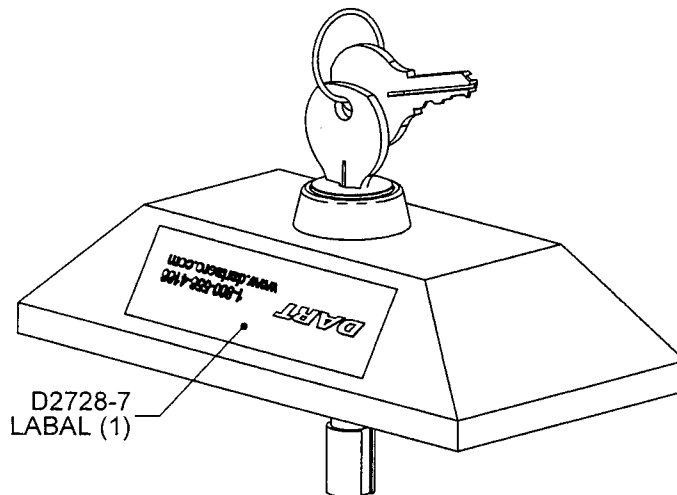
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



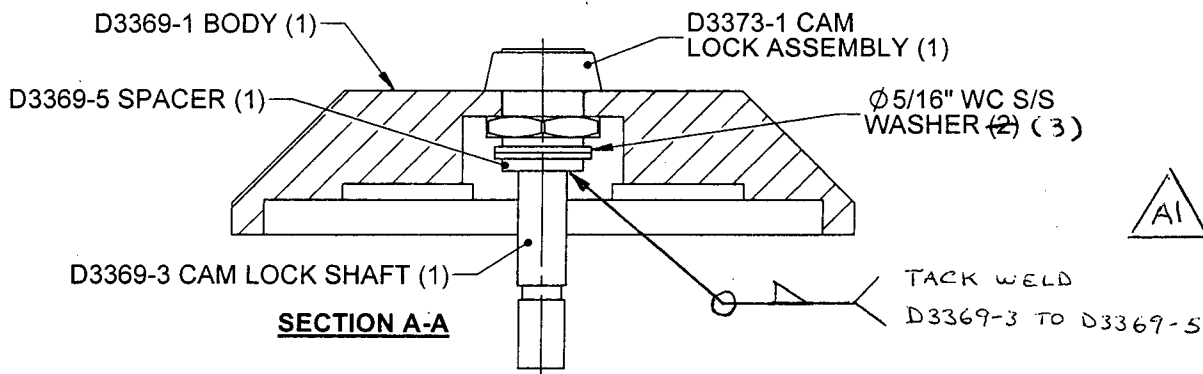
DESIGN 13	DRAWN BY 13	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED R	APPROVED MS	DRAWING NO. D3369	REV. A SHEET 1 OF 4
DATE 04.12.16		TITLE BATTERY LOCK	SCALE 1:1.5
A	04.12.16	NEW ISSUE	



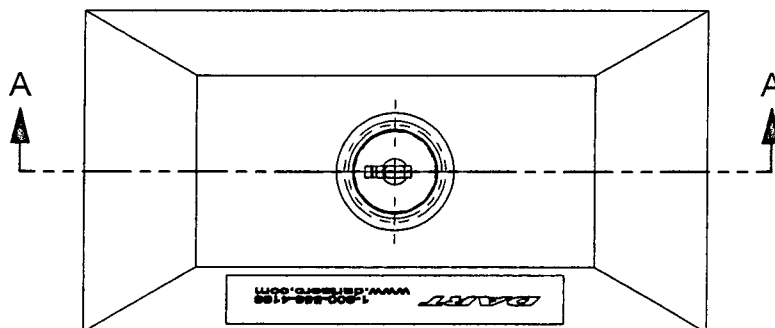
D2728-7
LABAL (1)

BATTERY LOCK SHOWN LOCKED WITH KEY

RELEASED
05/02/11



SECTION A-A



D3369-041 BATTERY LOCK ASSEMBLY

NOTES:

- 1) WELD PER DART QSI 004

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 22625

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ADD TACK WELD
0.865 WAS 0.925

A1 MOD# 05.02.11

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Mar 04, 2005
08:33 am

Work Order No : 0022625
Project Name : D3369-041
Project For : WK509
Work Order Type : Main
Main WO Number :
House Part Number : D3369-041
Description : Battery Lock
Manufactured : Yes
Amount Req'd : 4
Amount Done : 0
Start Date : 03-04-05
Est Finish Date :
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00